



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

REFERENCE ONLY

✓ D3304-041
Job Sheet 181483



Part No: D3304-041

Job Qty: 3 ea

UNDER REVIEW

Part Name: Tube Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/27/18

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Due Date: 8/22/18

Type: Stock

Note: DWG REV B IPP: C 04.11.17 Step 13 revised KJ/JLM

Ship Via:

Bin: ST 459 O.P.
Packaging 3-3-B4B

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea		8/22/18	0.00	0.00	Start Up Machining-2		JBD 18/10/06
100	Bandsaw	3 pcs		8/22/18	0.00	0.87	Bandsaw1		
110	Lathe Conv	3 pcs		8/22/18	0.00	1.67	Lathe Conv-1		
120	QC	3 pcs		8/22/18	0.00	0.00	QC2 Machining-2		
130	QC	3 pcs		8/22/18	0.00	0.00	QC8 Machining-2	SL 13/10/24	2018-10-25
140	Small Fab	3 pcs		8/22/18	0.00	0.70	Small Fab-3		19-6-18 DAS
150	QC	3 pcs		8/22/18	0.00	0.00	QC5		JUN 7 7 2019 40
160	Large Fab	3 pcs		8/22/18	0.00	0.96	Large Fab 1		9-89
170	QC	3 pcs		8/22/18	0.00	0.00	QC9		CPL
180	QC	3 pcs		8/22/18	0.00	0.00	QC5		CPL
190	Powdercoat	3 pcs		8/22/18	0.00	0.12	Powdercoat3		BL 19-7-10
200	QC	3 pcs		8/22/18	0.00	0.00	QC3		SMB 19/7/11
210	Small Fab	3 pcs		8/22/18	0.00	0.70	Small Fab-3		SMB 19/7/11
220	QC	3 pcs		8/22/18	0.00	0.00	QC5		VM JUL 11 2019
230	Packaging	3 pcs		8/22/18	0.00	0.00	Packaging3-1		JUL 12 2019 70
240	QC21-SA	3 Ea		8/22/18	0.00	0.00	QC21		9-89

DAS
71
9-89

M/138839 START: 10:30

CVT: 300 FINISH: 11:00

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
CBL-1240	Cable	3.1251 ft (1.0417 ea)	90-Start up Operation	5113791
M304TR0.875W.065	304 Round Tube .875 X .065W	4.0311 ft (1.3437 ea)	160-Large Fab	5110366
BLBS-0016	Pip Pin	3 pcs (1 ea)	210-Small Fab	5113757
CBL-460	Loop Sleeve	6 Ea (2 ea)	210-Small Fab	5118711
D3304-5	Bracket	3 Ea (1 ea)	210-Small Fab	5119399

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	CBL-1240	3	248	0
160-Large Fab	M304TR0.875W.065	4	20	0
210-Small Fab	BLBS-0016	3	12	0
	CBL-460	6	333	0
	D3304-5	3	18	0

QA Closed: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. _____		Rework ☐		Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐	
NCR No. _____		Scrap ☐		Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐		Quality ☐	
		Use-as-is ☐		Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐		Other ☐	
		Suspected Unapproved ☐		Large Fab ☐		Composite ☐		Supplier ☐			
Date :		Step #:		QTY Effective :						MRB (QSI042) Approval	
Description Work Order Deviation				Disposition						Completed By	
										Lead hand / Supervisor Approval Verification	
										QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY							
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐		Power Loss/Surge ☐		Positioned Wrong ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐		Folio/Program ☐		Outside Dimensions ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐		Grain ☐		Over/Under tolerance ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐		Weld ☐		Part Incorrect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐		Wrong Stock Pulled ☐		Part Lost/Missing ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐		Out of Sequence ☐		Part Moved ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐		Off-set ☐		Drawing ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐		Mislabeled ☐		Finish ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐		Fit/Function ☐		Misread ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Misaligned/off center ☐		Turning Sequence ☐	
Past Expiry Date ☐		Manufacturing Process ☐									
Misidentified ☐		Past Due ☐		OTHER :							

Part Specifications

Specifications could not be found.

Plex 7/27/18 2:36 PM Dart.lajeunesse.marie



Container No: S120366



Part: D3304-041

Job No: 181483

Serial No/Batch: S120366

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/18/19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																	
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1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S120366 Part: D3304 - 041 Job No: 181483 Serial No/Batch: S120366 Revision: Inspector: Exp Date: Instructions: Various STC's Date: 10/22/18				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																	
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